

Blue ship March 17

Work Order ID 114475

114475

Page 1

March-06-14 11:38:52 AM

Item ID: D3413-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: O-Ring

Stop

NS2

Start Date: 3/06/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/11/14 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3413	Rev A								

100

0.00

100

FLOW WATER JET

0.00

Waterjet

Memo

1-Cut as per Dwg D3413
Dwg Rev: *A*
Prog Rev: *A*

6 0 *Jan 14-03-7*

FLOW CNC Waterjet

304. 250" x 4.00"

2- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1.

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

Memo

0.00

QC

Quality Control

6 0 *Jan 14-03-7*

Work Order ID 114475

March-06-14 11:38:52 AM

114475

Page 2

Item ID: D3413-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: O-Ring

Start Date: 3/06/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/11/14 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID
120

Operation
Description
QC8- Inspect parts - second check

Set Up/
Run Hours
0.00 27
9.89

Tool ID
Tool #
Plan Code

Accept
Qty
Reject
Qty
Reject
Number
Insp.
Stamp

0.00 M31K

6 _____

120

QC

Quality Control

155

155

SprayPaint

Spray Painting

Memo

prime b 126032
delfleet blue b 126437
delfleet clear b 121703

0.00

6 0 0 A8
14-3-14

165

165

QC

Quality Control

Memo

0.00

0.00

ET 14-03-15 x6

Work Order ID 114475***114475***

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March-06-14 11:38:52 AM

Item ID: D3413-1

Accept

N900040100

Setup

Start ***NS1***

Revision ID:

Stop

NS2

Item Name: O-Ring

Start Date: 3/06/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/11/14 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Packaging

ST446

14/3/17

(6)

DAS
32
9-89

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Quality Control

Memo

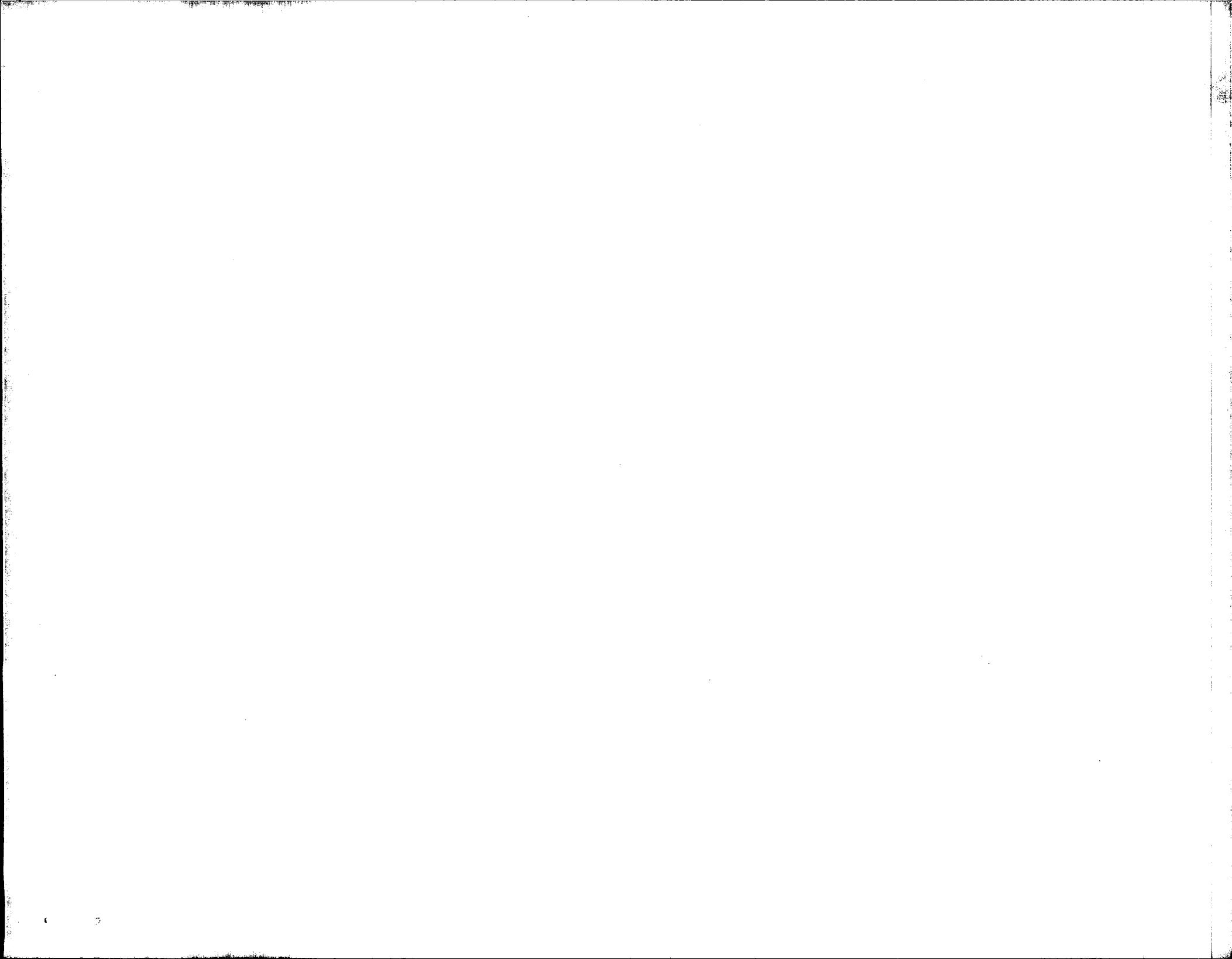
ST446

0.00

MC5

140377

WU, B17



Picklist Print

March-06-14 11:30:15 AM

Page 1

Work Order ID: 114475

Start Date: 3/06/14

Required Date: 3/11/14

Parent Item: D3413-1

Start Qty: 6.00

Required Qty: 6.00

Parent Item Name: O-Ring

Comments: IPP Rev:A05.09.13New issueKJ/JLM
IPP Rev:B Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250X4.000 304 BAR .250 x 4.00		Purchased	No			100	f	35.5000	0.25	②		3/14/037	

Location	Loc Qty	Loc Code
MAT051	35.5	
123313	11.5	
M128247	24	128247

DART AEROSPACE LTD	Work Order:	114475
Description: Ring	Part Number:	D3413-1
Inspection Dwg: D3413	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

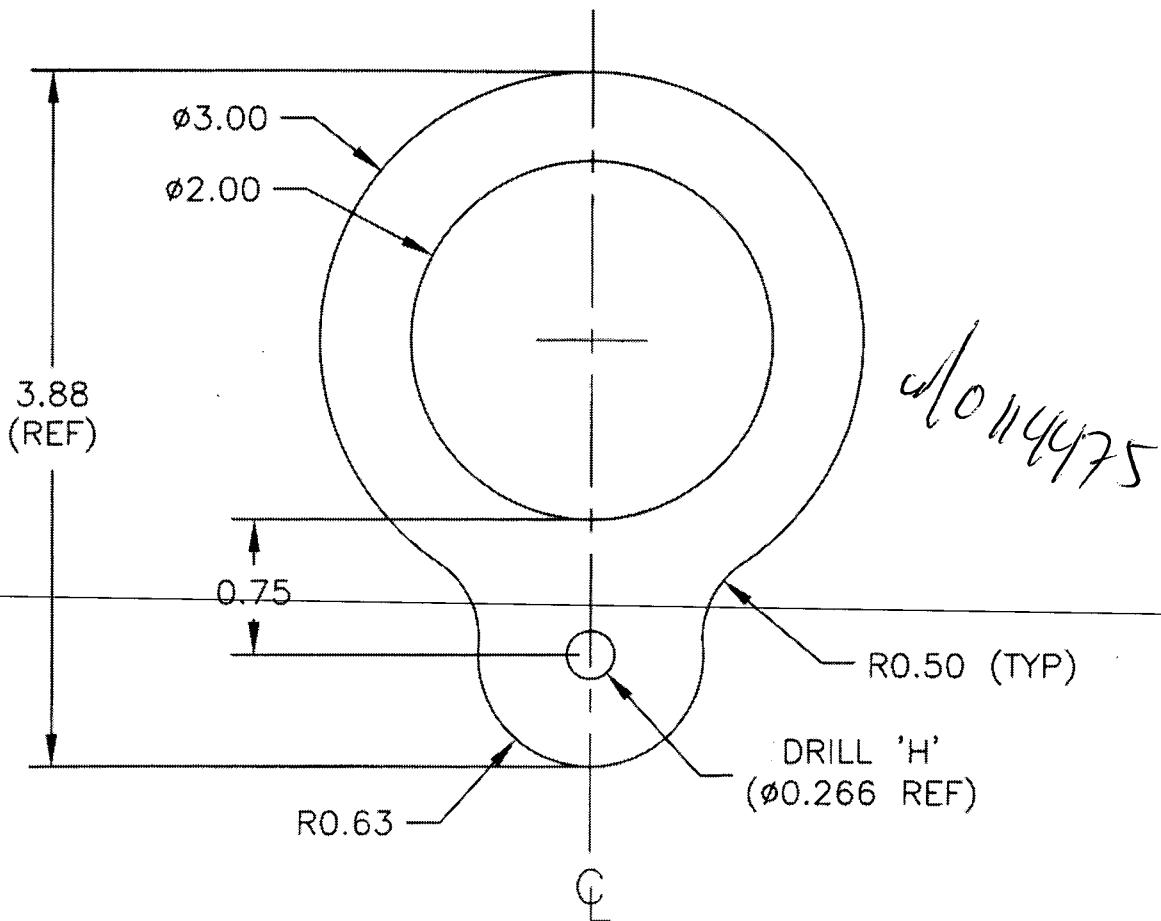
DAS

Measured by:	Jm	Audited by:	27 9-09	Prototype Approval:	N/A
Date:	14-03-7.	Date:	14/3/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	E

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3413 REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE RING SCALE 1:1
A	05.03.16	NEW ISSUE

RELEASED
05-09-06**D3413-1 RING**

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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